

Date: Tuesday, 03/03/2009 7:26:23 AM  
 User: Linda Lacelle

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : AFT TUBE ASSEMBLY  
 Job Number : 46227  
 Estimate Number : 10699  
 P.O. Number :  
 This Issue : 03/03/2009 S.O. No. :  
 Prsht Rev. : NC Part Number : D3391025  
 First Issue : / / Type : SKIDTUBES Drawing Number : D3391 REV H  
 Previous Run : 41762 Project Number : N/A  
 Material :  
 Due Date : 20/03/2009 Qty: 1 Um: Each  
 Written By :  
 Checked & Approved By :  
 Comment : Est Rev B 06-02-07 ECN773 dwg rev. D EC  
 Est Rev:C 06-03-28 Update Manuf. Instructions JLM  
 est rev D 07.03.20 revF dwg EC  
 est rev E 07.11.07 rev G dwg ecn 1053p EC verified by:  
 DD  
 Est Rev:F 07-11-13 ECN 1056 DD verified by: EC  
 Est Rev:G 08-09-10 revH as per dwg DD verified by:EC

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D6014090 ALUMINUM EXTRUSION



Comment: Qty.: 1.0000 f(s)/Unit Total: 1.0000 f(s)

ALUMINUM EXTRUSION

Pick:

Qty Part Number Description Batch  
 Extrusion 332309

Identify as D3391-3

A.m 09.03.04 (1)

2.0 MORI SEIKI MORI SEIKI CNC LATHE LARGE



Comment: MORI SEIKI CNC LATHE LARGE

Turn as per Folio FA599 Rev: AA & Dwg D3391 Rev: H

A.m/P.m 09-03-04

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

P.m / A.m 09-03-04 (2)

4.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS

1-Machine as per Folio FA 599 Rev: H & Dwg D3391 Rev: H

2-Deburr

J.L 09/03/17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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Part Number: D3391025

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

J.L 09/03/17

6.0

QC8

SECOND CHECK



Comment: SECOND CHECK

SP 09/03/18

7.0

SKIDTUBES 1

SKIDTUBESS RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Drill ( PILOT HOLE) aft cap holes per Dwg D3391 using DT8803

pm 09-03-19 @

8.0

BENDING

BENDING MACHINE - SKIDTUBES



Comment: NC Bender

Form as per Dwg D3391 Using Bend Prog 3391025

DP

9-3-19

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 09/03/23 @

10.0

SKIDTUBES 1

SKIDTUBESS RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Open Aft cap pilot hole to .208" as per Dwg D3391

2-Drill float bag holes using DT8809 as per Dwg D3391(Holes marked "A" Only.

3-Drill wearplate holes as per Dwg D3391 using DT8878(Mid Tube) & DT8217 Wearplate Jig .

\*\*\*\*\*Do Not Open To Finished Size\*\*\*\*\*

4-Drill Wearshoe holes as per DWG D3391 using DT8939 locating from 2 previously drilled aft wearplate holes.

5-Open wearplate holes to 0.250" and c'bore as per dwg D3391

6-Open up all wearshoe , wearplate to 0.297"and float bag holes to 0.328" as per Dwg D3391.

7-Deburr

Tools: rill

pm 09-03-24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Job Number: 46227

Part Number: D3391025

Job Number:



Seq. #:	Machine Or Operation:	Description :
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11.0	QC5	INSPECT WORK TO CURRENT STEP
------	-----	------------------------------



Comment: INSPECT WORK TO CURRENT STEP

S 09/03/25 @

12.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1  
Acid etch and Alodine as per QSI 005 4.1

pm 09-03-25

13.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
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Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

S 09/03/25 @

14.0	D36704200	SPACER
------	-----------	--------



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)  
SPACER  
batch: B 46106

pm 09-03-25 x 5

15.0	SKIDTUBES 1	SKIDTUBESS RESOURCE 1
------	-------------	-----------------------



Comment: LANDING GEAR RESOURCE 1  
Instal spacers as per dwg D3391

A/R Magnabond 6398 Batch: M 69900  
exp. date : 09/8/19  
cure time 12hrs as per QSI0015

pm 09-03-25 (1)

16.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

S 09/04/01 @

17.0	POWDER COATING	POWDER COATING
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Comment: POWDER COATING pressure wash 09-04-01 x 5  
Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

M 110939

START TIME: 8:30  
OVEN TEMPERATURE: 320  
FINISH TIME: 9:00

BR 09-04-2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Job Number: 46227

Part Number: D3391025

Job Number:



Seq. #:

Machine Or Operation:

Description :

18.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



HL



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

09-04-06

(X1)

19.0

D2646

Aft Cap



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Aft Cap

Pick:

Qty Part Number Description Batch  
1 D2646 Aft Cap

1346327

HL

20.0

D35371

Wearpad



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

WEARPAD

1345716

HL

21.0

D35377

Wearpad



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Wearpad

1333869

HL

22.0

D35531

Gasket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Gasket

1333868

HL

23.0

D35533

Gasket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Gasket

1333870

HL

24.0

D36721

Phenolic Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

PHENOLIC WASHER

1339275

HL

25.0

ALS41032130

Insert



Comment: Qty.: 14.0000 Each(s)/Unit Total : 14.0000 Each(s)

INSERT

batch: 17108606

\*HL

09-04-06

(X1)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Job Number: 46227

Part Number: D3391025

Job Number:



Seq. #:

Machine Or Operation:

Description :

or equivalent per  
QSI 017

21 09-04-06 (X1)

26.0

ALS41032225

Insert



Comment: Qty.: 12.0000 Each(s)/Unit Total : 12.0000 Each(s)

INSERT

or equivalent

Per QSI 017

1119393

21

27.0

AN3C4A

BOLT



Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s)

Bolt

Pick:

Qty	Part Number	Description	Batch
2	AN3C4A	Bolt	1111279

1111279

21

28.0

AN3C5A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Bolt

1110916

21

29.0

AN960C10L

washer



Comment: Qty.: 10.0000 Each(s)/Unit Total : 10.0000 Each(s)

Inventory

Pick:

Qty	Part Number	Description	Batch
2	AN960C10L	Washer	1110916

1110916

21

30.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: SMALL & MEDIUM FAB RESOURCE 1

✓ 1-Install inserts as per Dwg D3391

2-Install Aft Cap as per Dwg D3391

✓ A/R Sikaflex-241/-291 1111087

Sikaflex expiry date: 10/20

21

09-04-06 (X1)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Job Number: 46227

Part Number: D3391025

Job Number:



Seq. #:

Machine Or Operation:

Description :

31.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*20904.07 ①*

32.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *W/O 46808*

*20904.07 ①*

33.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

*09/04/14*

Job Completion



*W 09.04.09*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 46227
<b>Description:</b> Float Skidtube (412)		<b>Part Number:</b> D3391-3
<b>Inspection Dwg:</b> D3391	<b>Rev:</b> 4	<b>Page 1 of 1</b>

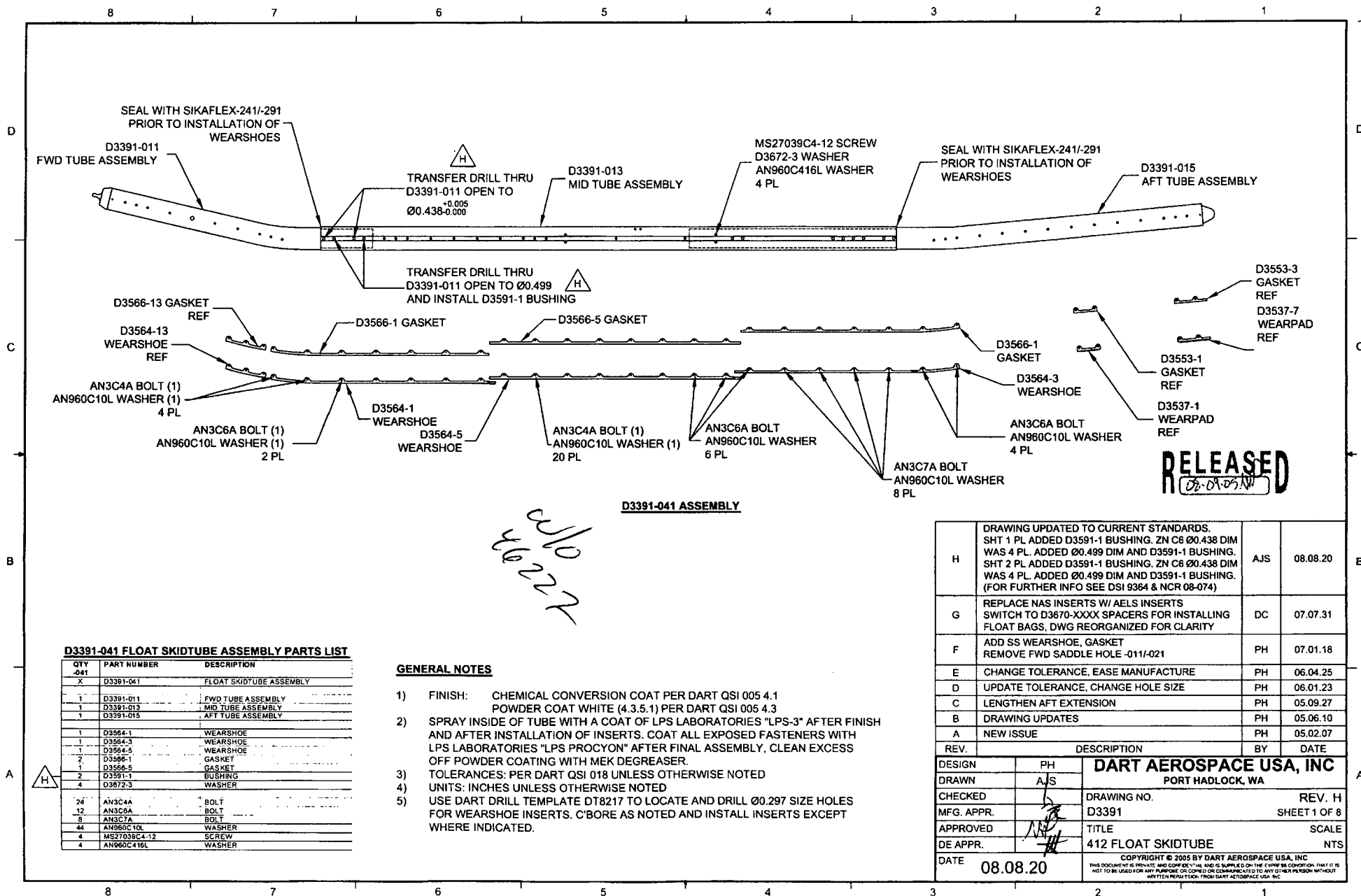
### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

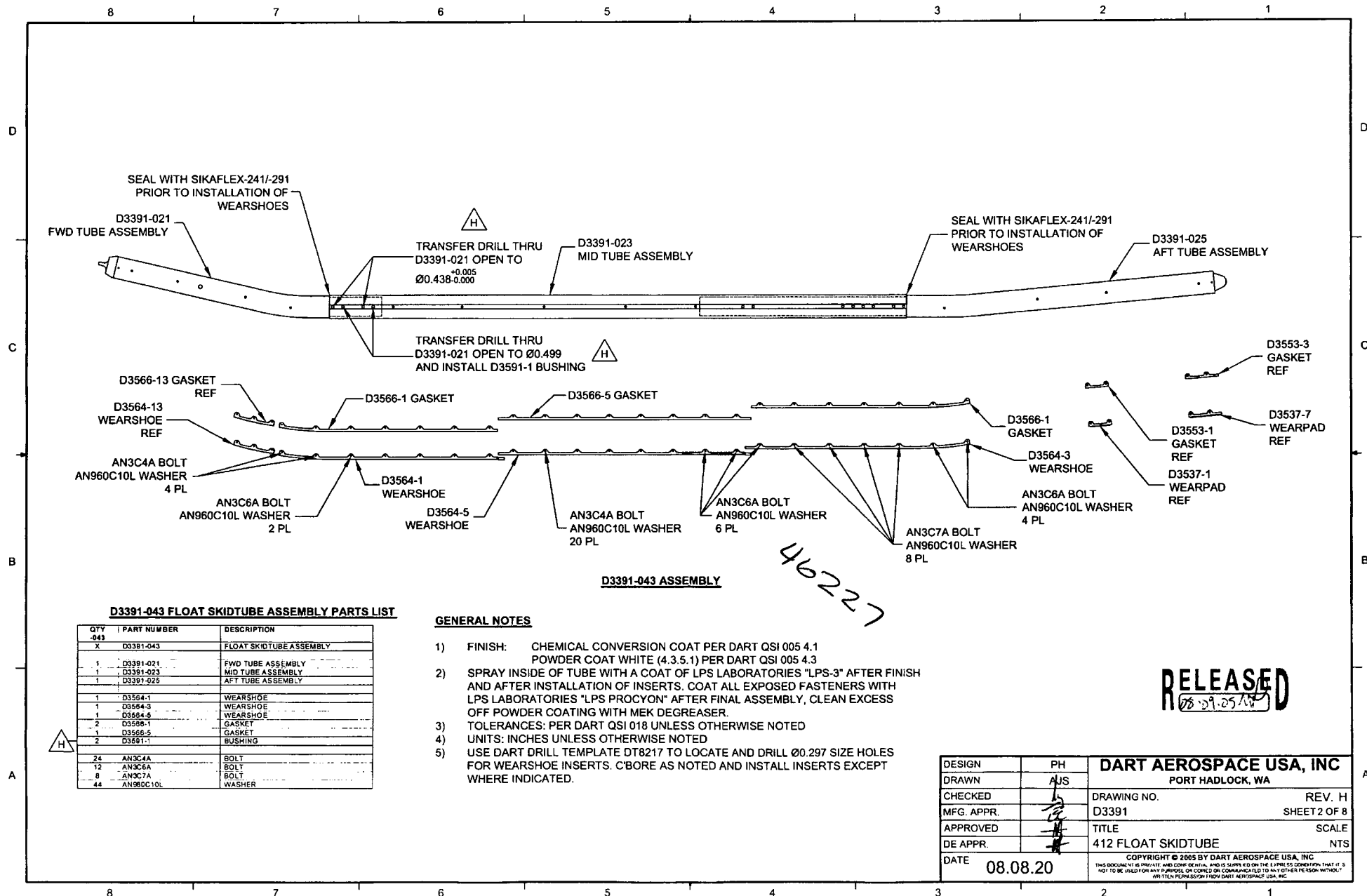
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
14.000	+/-0.010	14.000	✓			
3.500	+/-0.010	3.496	✓			
88.93	+/-0.030	88.930	✓			
<del>44.995</del>	<del>+/-0.030</del>					
3.200	+/-0.010	3.202	✓			
1.526	+0.000/-0.030	1.510	✓			
0.200	+/-0.010	.202	✓			
7.500	+/-0.010	7.498	✓			
27.750	+/-0.010	27.750	✓			
31.750	+/-0.010	31.750	✓			
35.250	+/-0.010	35.250	✓			
3.300	+/-0.010	3.301	✓			
0.200	+/-0.010	.208	✓			
3.520	+/-0.010	3.519	✓			
0.687	+0.010/-0.000	.689	✓			
R0.062	+/-0.010	0.062	✓			
Ø0.484	+0.005/-0.001	.488	✓			

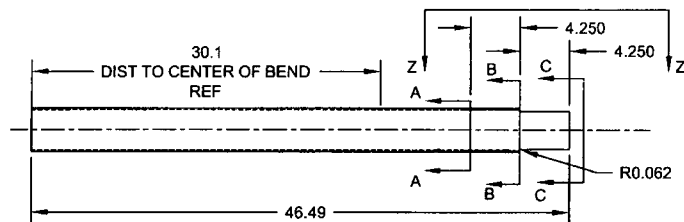
<b>Measured by:</b> J.L.	<b>Audited by:</b> SP	<b>Prototype Approval:</b>	N/A
<b>Date:</b> 09/03/17	<b>Date:</b> 09/03/18	<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
A	06.04.24	New Issue P/O D3391-015/-025	KJ/JLM	
B	06.06.19	Dwg revision update	KJ/JLM	
C	07.04.20	Ø0.208 dimension removed	KJ/JLM	
D	07.09.06	0.400 dimension removed	KJ/JLM	
E	07.11.23	Dwg Rev. updated	KJ/EC/DD	

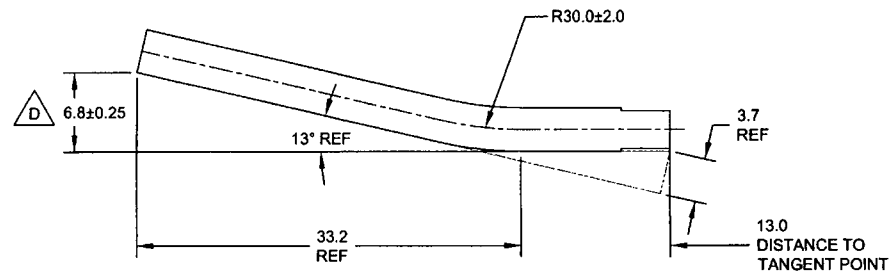


H	DRAWING UPDATED TO CURRENT STANDARDS. SHT 1 PL ADDED D3591-1 BUSHING. ZN C6 Ø0.438 DIM WAS 4 PL. ADDED Ø0.499 DIM AND D3591-1 BUSHING. SHT 2 PL ADDED D3591-1 BUSHING. ZN C6 Ø0.438 DIM WAS 4 PL. ADDED Ø0.499 DIM AND D3591-1 BUSHING. (FOR FURTHER INFO SEE DSI 9364 & NCR 08-074)	AJS	08.08.20
G	REPLACE NAS INSERTS W/ AELS INSERTS SWITCH TO D3670-XXXX SPACERS FOR INSTALLING FLOAT BAGS. DWG REORGANIZED FOR CLARITY	DC	07.07.31
F	ADD SS WEARSHOE, GASKET REMOVE FWD SADDLE HOLE -011/-021	PH	07.01.18
E	CHANGE TOLERANCE, EASE MANUFACTURE	PH	06.04.25
D	UPDATE TOLERANCE, CHANGE HOLE SIZE	PH	06.01.23
C	LENGTHEN AFT EXTENSION	PH	05.09.27
B	DRAWING UPDATES	PH	05.06.10
A	NEW ISSUE	PH	05.02.07
REV.	DESCRIPTION	BY	DATE
DESIGN	PH	<b>DART AEROSPACE USA, INC</b> PORT HADLOCK, WA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. H
MFG. APPR.		D3391	SHEET 1 OF 8
APPROVED		TITLE	SCALE
DE APPR.		412 FLOAT SKIDTUBE	NTS
DATE	08.08.20	COPYRIGHT © 2005 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

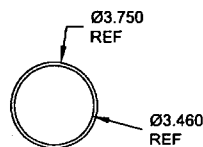




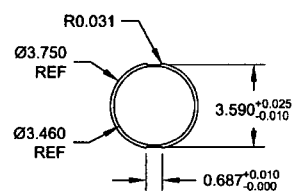
**D3391-1 CUTTING DETAIL**  
(MAKE FROM D6013-047 SKIDTUBE MATERIAL)



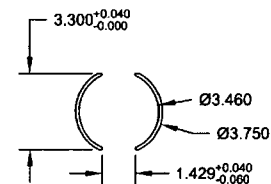
**D3391-011/-021 BENDING DETAIL**  
(MAKE FROM D3391-1)



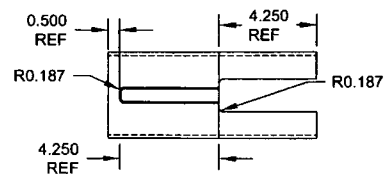
**SECTION A-A**  
SCALE 2X



**SECTION B-B**  
SCALE 2X



**SECTION C-C**  
SCALE 2X

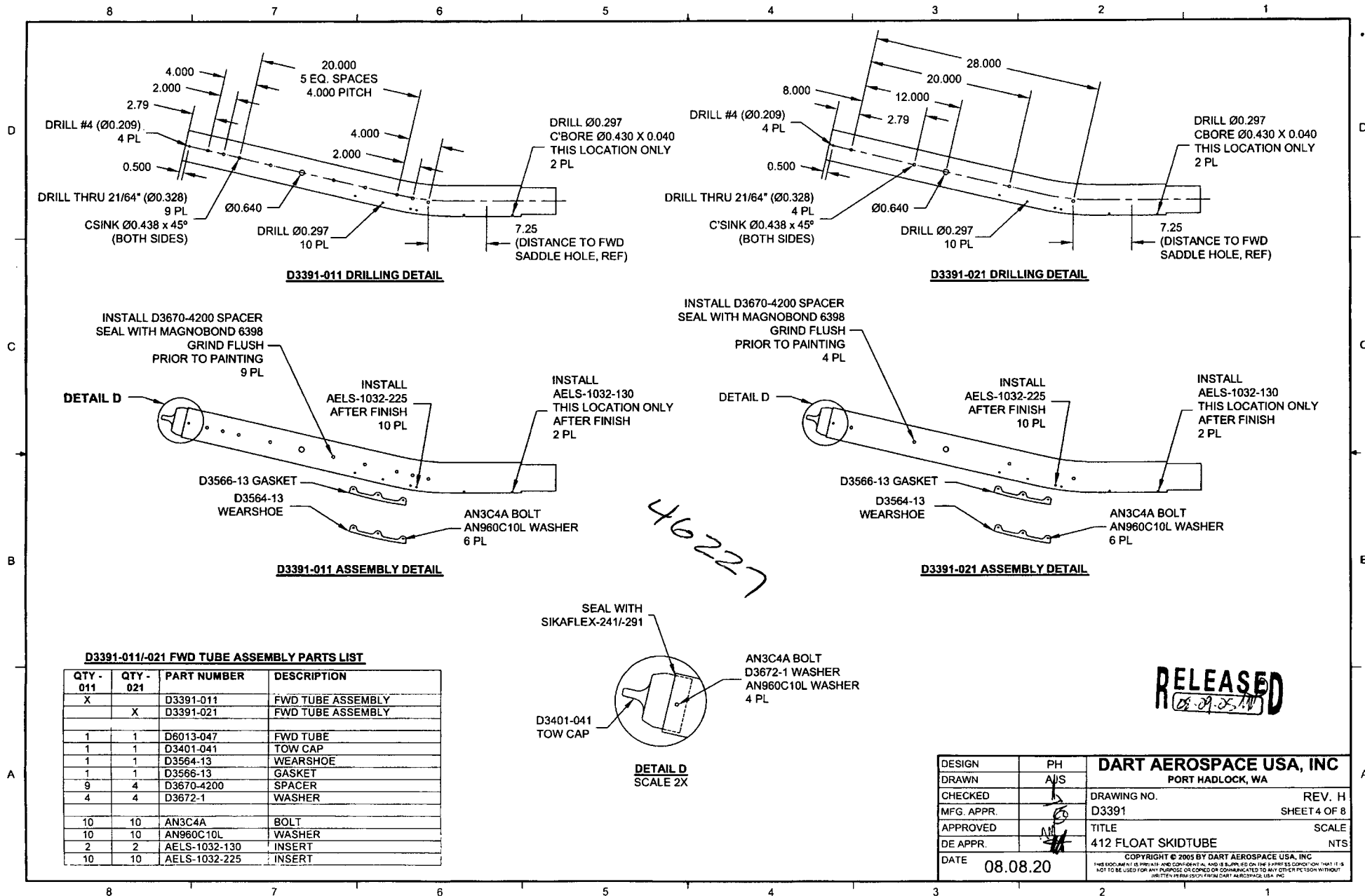


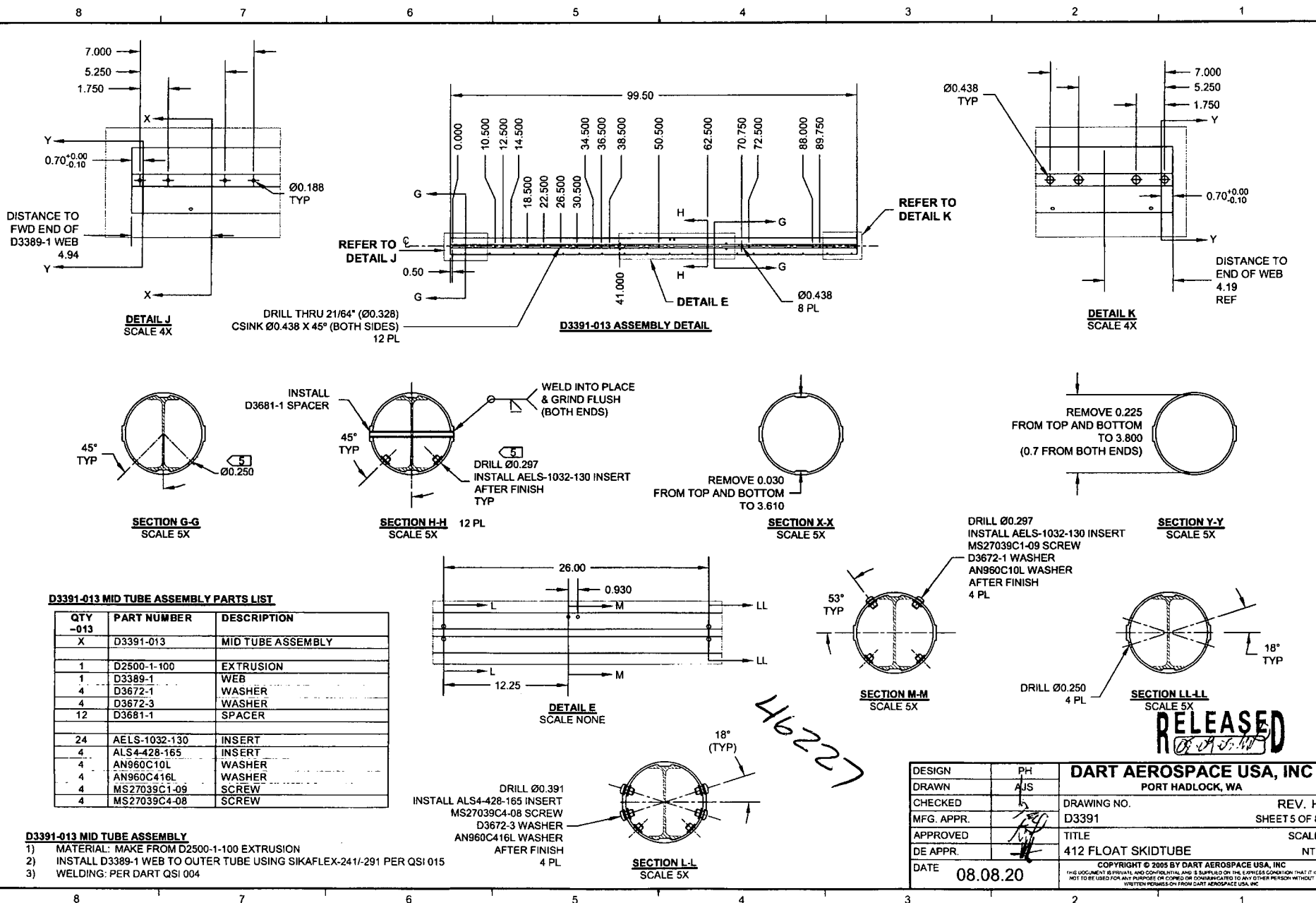
**VIEW Z-Z**  
SCALE 2X

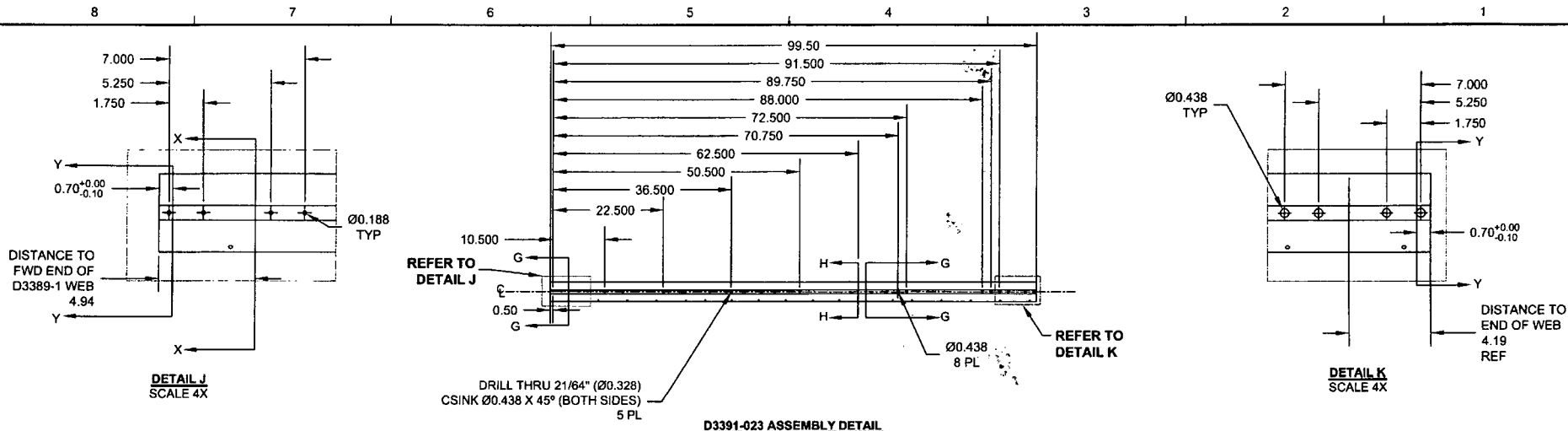
**RELEASED**  
8-9-05

DESIGN	PH	<b>DART AEROSPACE USA, INC</b>	
DRAWN	AUS	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. H
MFG. APPR.		D3391	SHEET 3 OF 8
APPROVED		TITLE	SCALE
DE APPR.		412 FLOAT SKIDTUBE	NTS
DATE	08.08.20	COPYRIGHT © 2005 BY DART AEROSPACE USA, INC	
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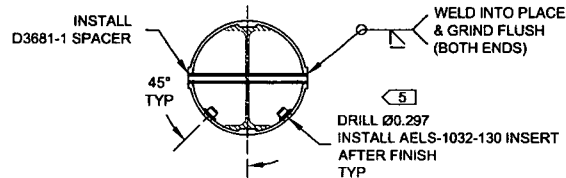




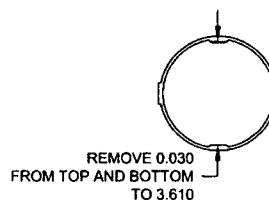




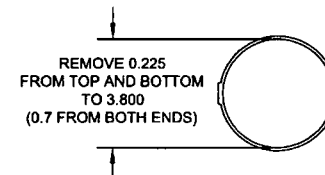
SECTION G-G  
SCALE 5X



SECTION H-H  
SCALE 5X



SECTION X-X  
SCALE 5X



SECTION Y-Y  
SCALE 5X

**D3391-023 MID TUBE ASSEMBLY PARTS LIST**

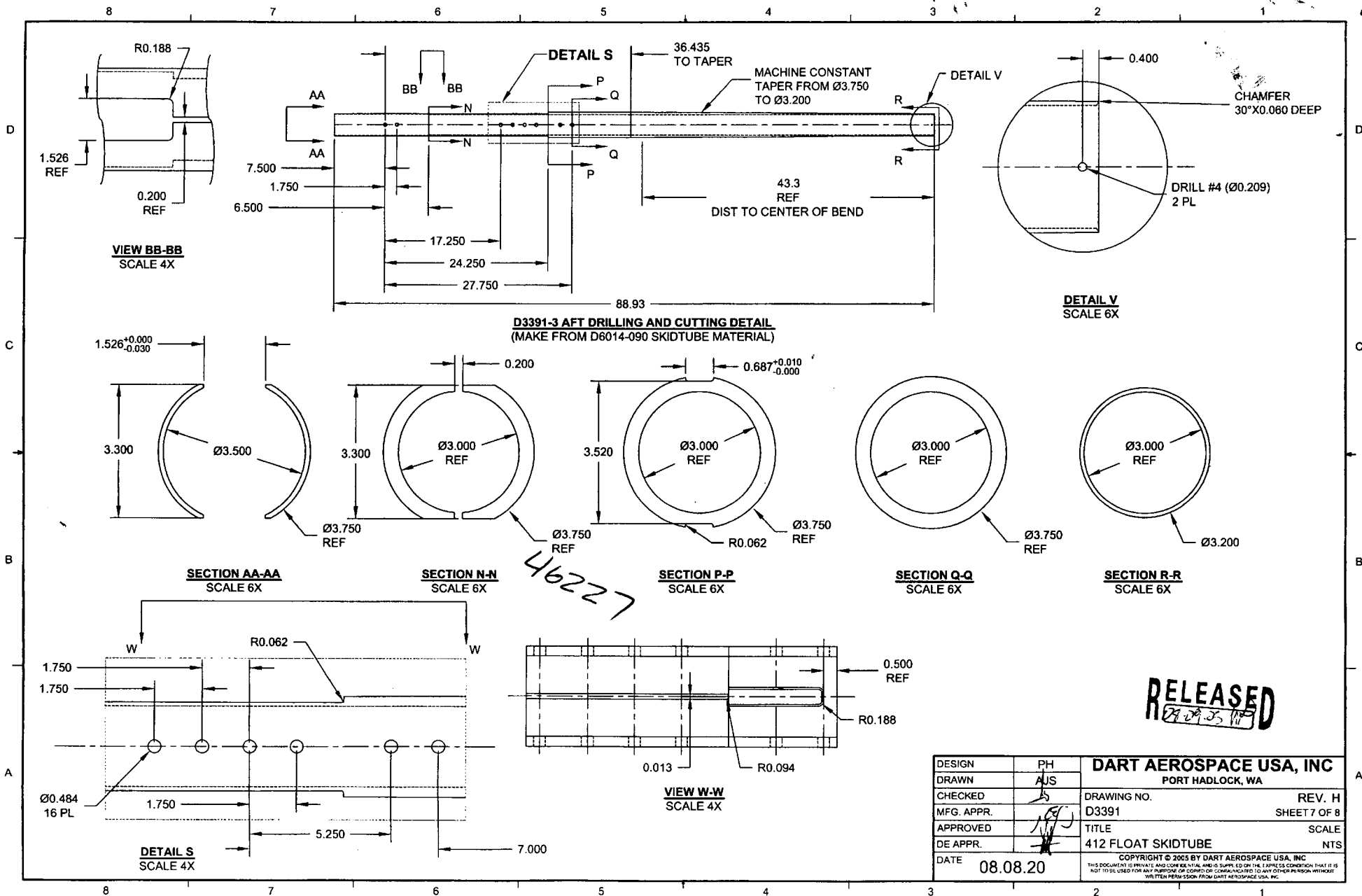
QTY - 023	PART NUMBER	DESCRIPTION
X	D3391-023	MID TUBE ASSEMBLY
1	D2500-1-100	EXTRUSION
1	D3389-1	WEB
5	D3681-1	SPACER
20	AELS-1032-130	INSERT

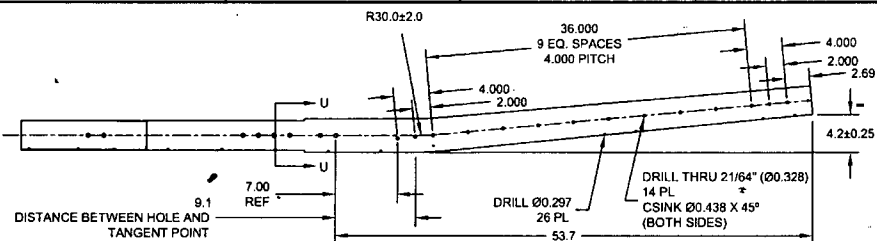
**D3391-023 MID TUBE ASSEMBLY**

- 1) MATERIAL: MAKE FROM D2500-1-100 EXTRUSION
- 2) INSTALL D3389-1 WEB TO OUTER TUBE USING SIKAFLEX-241/291 PER QSI 015
- 3) WELDING: PER DART QSI 004

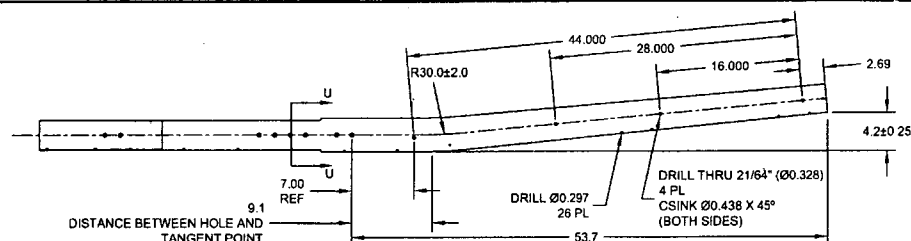
RELEASED  
08-08-20

DESIGN	PH	<b>DART AEROSPACE USA, INC</b>
DRAWN	AJS	PORT HADLOCK, WA
CHECKED		DRAWING NO. REV. H
MFG. APPR.		D3391 SHEET 6 OF 8
APPROVED		TITLE SCALE
DE APPR.		412 FLOAT SKIDTUBE NTS
DATE	08.08.20	COPYRIGHT © 2005 BY DART AEROSPACE USA, INC

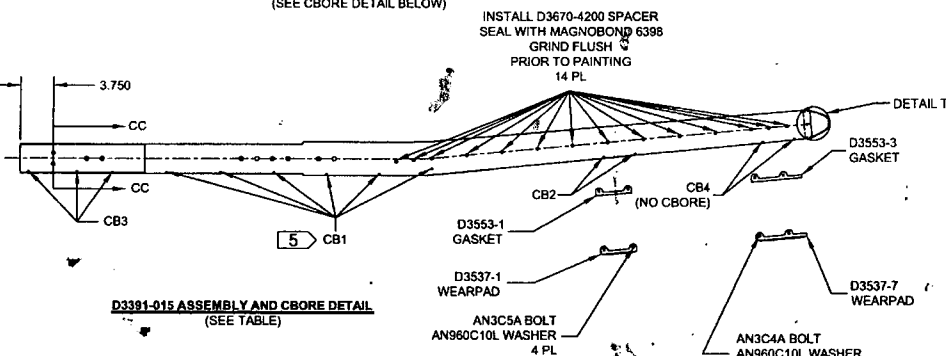




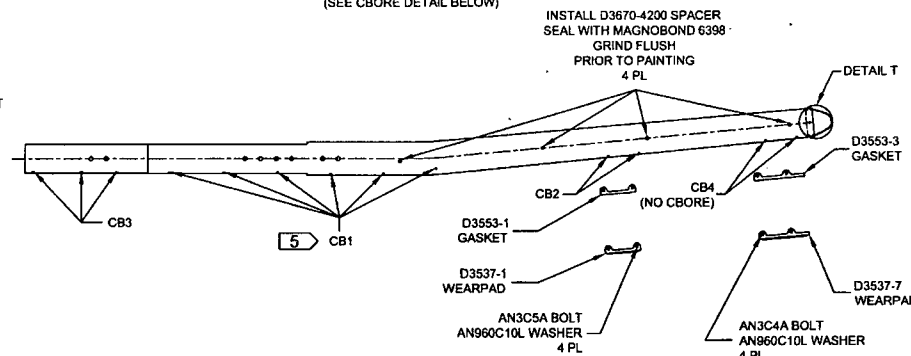
**D3391-015 BENDING AND DRILLING DETAIL**  
(SEE CBORE DETAIL BELOW)



**D3391-025 BENDING AND DRILLING DETAIL**  
(SEE CBORE DETAIL BELOW)



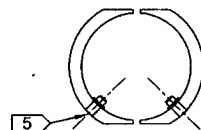
**D3391-015 ASSEMBLY AND CBORE DETAIL**  
(SEE TABLE)



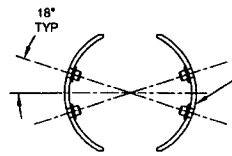
**D3391-025 ASSEMBLY AND CBORE DETAIL**  
(SEE TABLE)

**D3391-015-025 AFT TUBE ASSEMBLY PARTS LIST**

QTY - 015	QTY - 025	PART NUMBER	DESCRIPTION
X	X	D3391-015	AFT TUBE ASSEMBLY
		D3391-025	AFT TUBE ASSEMBLY
1	1	D6014-090	AFT TUBE
1	1	D2646	AFT CAP
1	1	D3537-1	WEARPAD
1	1	D3537-7	WEARPAD
1	1	D3553-1	GASKET
1	1	D3553-3	GASKET
14	4	D3670-4200	SPACER
2	2	D3672-1	WASHER
14	14	AELS-1032-130	INSERT
12	12	AELS-1032-225	INSERT
4	4	ALS4-428-165	INSERT
6	6	AN3C4A	BOLT
4	4	AN3C5A	BOLT
10	10	AN960C10L	WASHER

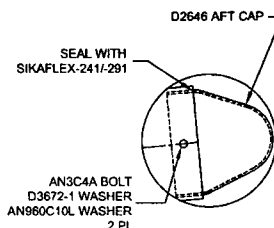


**SECTION U-U**  
SCALE 3X



**SECTION CC-CC**  
SCALE 3X

DRILL Ø0.391  
CBORE Ø0.516 X 0.040 DEEP  
INSTALL ALS4-428-165 INSERT  
4 PL



**DETAIL T**  
SCALE 4X

CBORE HOLES MARKED CB1-CB4 AS FOLLOWS AND  
INSTALL AELS-1032-XXX AFTER FINISH AS NOTED

HOLES MARKED	QTY D3391-015	QTY D3391-025	CBORE	P/N
CB1	12	12	Ø0.430 X 0.170	AELS-1032-225
CB2	4	4	Ø0.430 X 0.170	AELS-1032-130
CB3	6	6	Ø0.430 X 0.040	AELS-1032-130
CB4	4	4	NONE	AELS-1032-130

DESIGN	PH	<b>DART AEROSPACE USA, INC</b>
DRAWN	ALS	PORT HADLOCK, WA
CHECKED	ALS	DRAWING NO. REV. H
MFG. APPR.	ALS	D3391 SHEET 8 OF 8
APPROVED	ALS	TITLE SCALE
DE APPR.	ALS	412 FLOAT SKIDTUBE NTS
DATE	08.08.20	COPYRIGHT © 2003 BY DART AEROSPACE USA, INC

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